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D2521

Job Sheet 187305



Part No: D2521

Job Qty: 8 ea

Part Name: Individual Bearpaw



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/30/18

Job Tracking No:

Due Date: 1/11/19

Created By: Jesse White

Type: Stock

Description:

Note: DWG REV J IPP Rev:A 08-10-01 New Manufacturing Method JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea	1/11/19	1/11/19	0.00	0.00	Start Up Container		18/12/03
120	Waterjet - Flow - B4B	8 pcs	1/11/19	1/11/19	0.00	3.01	Waterjet 2 OMAX		DAS 18/12/03
130	CNC Vertical Machining	8 pcs	1/11/19	1/11/19	0.39	13.89	HAAS 1		52 18/12/20
140	QC	8 pcs	1/11/19	1/11/19	0.00	0.00	QC2		9-89 18/12/20
150	QC	8 pcs	1/11/19	1/11/19	0.00	0.00	QC8		18/12/21
160	Packaging	8 pcs	1/11/19	1/11/19	0.00	0.00	Packaging3		5479
170	QC21-SA	8 Ea	1/11/19	1/11/19	0.00	0.00	QC21		21 DEC 21 2018

Part Op 120 - Cut Blank as per D2521 blank file

Descriptions: 130 - 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio and Dwg D2521 Identify as D2521

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	56 sf (7 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MUHMWB10	56	339	0

Part Specifications

Specifications could not be found.

Plex 11/30/18 8:33 AM dart.white.jesse

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			
		Other/Details: _____			

DART AEROSPACE LTD		Work Order:	
Description: Bearpaw		Part Number:	D2521
Inspection Dwg: D2521 Rev: J		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Inspection Sheet Drawing Dimension			Actual Dimension	Accept	Reject	Method of Inspection	Comments
Dim	Min	Max					
A	0.260	0.266	0.261	✓		G.P	
B	0.90	0.96	0.930	✓		Ver	
C	0.27	0.330	0.310	✓		D.G.	
D	0.470	0.530	0.500	✓		Ver	
E	21.740	21.760	21.750	✓		TAPE	
F	0.72	0.780	0.750	✓		Ver	
G	0.35	0.410	0.380	✓		Ver	
H	11.490	11.570	11.500	✓		TAPE	
I	3.41	3.47	3.44	✓		Ver	
J	11.790	11.810	11.800	✓		TAPE	
K	9.47	9.53	9.500	✓		TAPE	
L	7.190	7.210	7.200	✓		TAPE	
M	6.910	6.970	6.940	✓		Ver	
N	44.47	44.530	44.500	✓		TAPE	
O	6.590	6.650	6.620	✓		Ver	
P	0.940	0.980	0.965	✓		Ver	
Q	18.97	19.03	19.000	✓		TAPE	
R	0.350	0.410	0.380	✓		Ver	
S	0.740	0.780	0.770	✓		Ver	
T	0.240	0.280	0.265	✓		Ver	
U	0.370	0.410	0.382	✓		Ver	
V	0.740	0.780	0.765	✓		Ver	
W	0.740	0.780	0.765	✓		Ver	

DAS
52

Measured by: 9-89	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: 18/12/19	Date: 18/12/21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D205-564-011 & D430-688-011	KJ/RF	
B	05.06.15	Dimensions and tolerances changed	KJ/RF	
C	06.08.31	Dimensions updated per D2521 Rev. J	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>



Container No: S134193



Part: D2521

Job No: 187305

Serial No/Batch: S134193

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 12/03/18